

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013672**Date Inspected:** 01-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 12CW, weld No. SEG3004X-071. The welder is identified as #063326. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

FCAW in the 2F position for the OBG Segment 12CW, weld No. SEG3004V-086. The welder is identified as #047864. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Bay #19

FCAW in the 2G position for the OBG Suspender Bracket , weld No. SB007-048-022. The welder is identified as #047864. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

FCAW in the 2F position for the OBG Suspender Bracket, weld no. SB008-048-022. The welder is identified as #062757. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing (MPT) for 9DW

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Segment 9DW. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SSD11A-PP81-144,145  
CSD9-PP81-062,050,016,008

During the Quality Assurance Magnetic particle Testing (MT) review of welds located on Orthotropic Box Girder (OBG) Segment 9DW this Quality Assurance Inspector (QA) discovered the following issue that One (1) longitudinal linear indication measuring approximately 18mm in length. The Y location is 7mm from the cope hole. The indication is clearly marked on the material near the weld. The weld is identified as: CSD9-PP81-062. The weld is designated as Seismic Performance Critical Member (SPCM). The weld is located at PP81 (Counter Weight Side). The weld is a Fillet Weld T-joint joining the Corner Assembly Diaphragm identified as X11B (SPCM) to Side Plate identified as SP658 (SPCM). OBG segment 9DW is located west of Bay #14. The Notice of Witness Inspection Number (NWIT) is 005616. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% MT inspection of this weld.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

---